

Date: Wednesday, 3/8/2006 10:39:00 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : EYEBALL ADAPTER
Job Number : 26134	
Estimate Number : 12239	
P.O. Number : N/A	Part Number : D34801
This Issue : 3/8/2006 S.O. No. : N/A	Drawing Number : D3480 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : <u>See Comment Below</u>	Due Date : 3/31/2006 Qty: 40 Um: Each
Checked & Approved By : <u>06.03.08</u>	
Comment : est rev. A 06.02.07 new issue EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	OUTSIDE SERVICE	OUTSIDE SERVICES
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Comment: Sub-Contracting Issue P/O: 00000768 06/03/09  
 Email or Ship DXF file to vendor  
 Laser Cut per Dwg D3480 flat pattern D3480-1F  
 Material release note required

2.0	D34801F	Flange flat pattern
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 24.0000 Each(s)  
 DOUBLER FLAT PATTERN

(40)

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 Receive & Inspect For Transit Damage  
 Ensure material certification is attached

06/03/21

(40)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

06.03.22

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Form as per dwg D3467 using DT8857

Permanent Changes  
06.03.28

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 3/8/2006 10:39:00 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EYEBALL ADAPTER

Job Number: 26134

Part Number: D34801

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

Stock as 3480-1F

06.03.28

(39)

PTD

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.03.29

(37)

Job Completion



06.03.29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		One kept as template	18	06/03/20	1	18 CERN	18 06/03/20
	7	Stock as D3480-1F Permanent Change				18 06/03/20	18 06/03/20

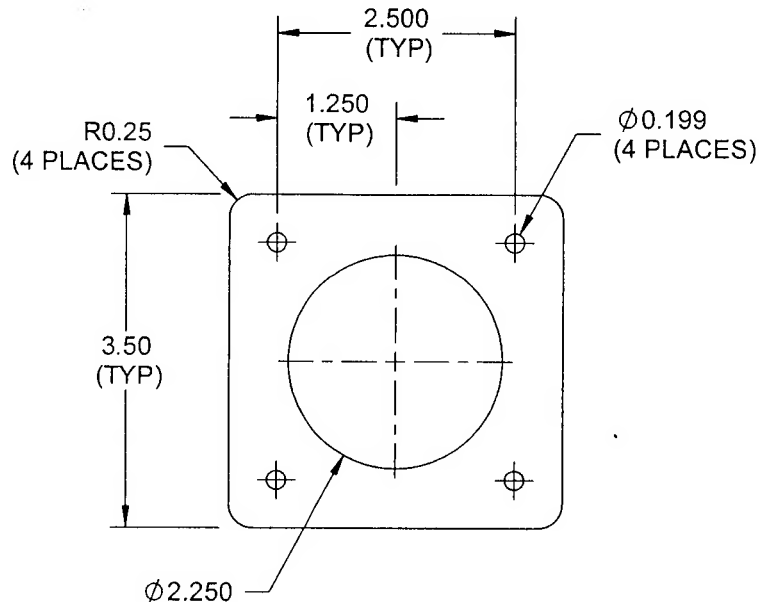
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/03/20  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

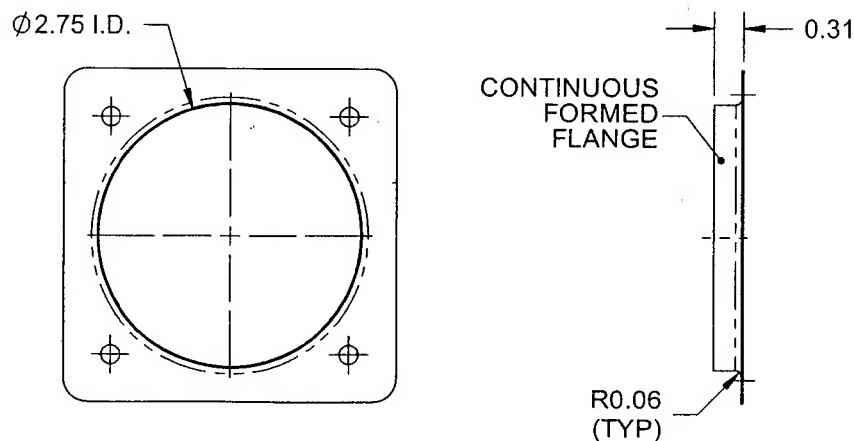
NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3480	REV. A SHEET 3 OF 6
DATE 06.02.06		TITLE EYEBALL ADAPTER	SCALE 1:2



**D3480-1F FLAT PATTERN**



**D3480-1 FLANGE**  
(MAKE FROM D3480-1F)

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010



3/17/06

604-946-453 ATTN: PETE

03/17/2006 14:36 FAX 604 946 4153  
03/17/2006 14:18 FAX 604 946 4153INDUSTRIAL LASER CUTTING  
INTEGRIS METALS002  
001/004

3/17/2006 1:57 PAGE 001/002 Fax Server


Ryerson

T-726 P.007/015 F-587

253-288-8888

FROM-INTEGRIS

MAY-17-2006 18:05

		<b>AK Steel Corporation</b> <b>Metallurgical Test Report</b> <b>Coshocton Works</b> <b>Coshocton, OH 43812</b>		Page 1											
				Lead No. 7410672 SER No. 7410672											
INTEGRIS METALS PO BOX 340 MINNEAPOLIS, MN 55440	INTEGRIS METALS 306 "B" STREET ALBURN, WA 98001	MILL ORDER NO. 772184-0191 PART NO. 74151491		PROCESSOR ORDER NO. 427126-01 BUYER ORDER NO. 427126-01											
		ENGLISH UNITS -PRODUCT- METRIC UNITS 315 NOM 48.000 X COIL													
SKID ID	PIECE	HEAT	PARENT COIL ID	NET WEIGHT											
SK07131A3	1	7250151	050919-01	3,465 LBS. 4012 KG.											
SK07131A4	1	7250151	050919-01	3,470 LBS. 4013 KG.											
SK07131A5	1	7250151	050919-01	3,525 LBS. 4085 KG.											
SK07131A6	1	7250151	050919-01	3,441 LBS. 3991 KG.											
TOTAL SKIDS	TOTAL PIECES			TOTAL NET WEIGHT											
4	4			13,841 LBS. 15,075 KG.											
L-Lab Analysis of Heat      P-Product Analysis of Parent Coil <b>CHEMICAL ANALYSIS</b>															
ID	C	MN	P	S	SI	CR	NI	MO	N	CU	CO				
L 7250151	.049	1.39	.027	.001	.35	18.18	8.05	.35	.04	.30	.12				
SHIPPING DATE: 09/13/2005      REMARKS: NO INTENTIONAL ADDITIONS OF MERCURY OR MERCURY COMPOUNDS, RADIUM, ALPHA SOURCE, AND LOW MELTING ALLOYS OR ELEMENTS CAPABLE OF FORMING LOW MELTING ALLOYS WERE MADE THROUGHOUT THE PROCESSING OF THIS MATERIAL.						<b>PRODUCT DESCRIPTION</b> CR SBT TYPE 304 STAINLESS #2B FINISH SLIT EDGE * AMS 3512 & ALL TECH REQS HAVE BEEN MET UNLESS MARKED TO OR NOTED OTHERWISE * A STR A 240 -04 EX PARA 3.1.1.3 ELONG WILL BE DETERMINED BY ASTM E 8 * ASTM A 490 -01 EX PARA 19.1.1 ELONG WILL BE DETERMINED BY ASTM E 8 H & S EX PARA 25.1.1.3 COIL WILL BE TAGGED ON OUTSIDE ONLY * ASTM A 866 -03 * IN-011 Rev 0, * IN-011 0 * BUYER PART# 78251491 * ASME SA-240 SECTION II PART A (2001 ED. 2002 ADDENDA) EX PARA 3.1.1.3 ELONG WILL BE DETERMINED BY ASTM E 8 * EN-10204 3.1.3									
PARENT COIL ID	FOR (R/T)	DIR (L, T, D)	COND	% ELONG 2 INCH MEASURED	TENSILE STRENGTH (KSI)	YS. % OFFSET (KSI)	ROCKWELL HARDNESS 'Tol'	ROCKWELL HARDNESS 'Front'							
050919-01	T	T	ASTM	71.0	125.2	27.1	72	74							
*** CONTINUED ON NEXT PAGE ***															

## Fax Server

T-726 P.008/015 F-527

002/004





# MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN  
740 IMPERIAL ROAD NORTH

Page : 1  
Heat/Lot : 66K8  
TIN : B42748

Sold To: INTEGRIS METALS, LTD.  
7910 43TH STREET SE  
CALGARY, AB T2C2Y3

Ship To: \*\*\*CUSTOMER PICKUP\*\*\*  
4375 14TH STREET NORTHEAST  
CALGARY  
ABT3E7A9

### Vendor Information

**Cust PO #: 416824**

Cust PO DT: 11/03/05

### Specifications

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.  
ASTMA240/04a 480/04a,666/03,ASME SA240/04-A05,480/04-A05,SA666/04  
QCS766D-A X 1/8 FRM,AMS5513H X MRK&FIN,MIL5059D,AMD3,X CRWN MEAS  
CORROSION: ASTM A262/02aE;180Bend-OK  
Buyer Part: 4288441  
304 2B .1305 IN 48 IN 96 IN  
Country of Origin: UNITED STATES

### Mechanical Tests

		DOM	L	O	DOM	L	O
Yield Strength - 0.2% Offset	40	KSI	F	TRANSV			
Tensile Strength (UTS)	93.3	KSI	F	TRANSV			
Rockwell B	85		F	TRANSV			
Pct Uniform Elong 2 In/50mm	57.01	PCT	F	TRANSV			
Rockwell A	85		T	TRANSV			

### Chemical Composition

C	Carbon-Pct	.059	CR	Chromium-Pct	18.360
CU	Copper-Pct	.342	MN	Manganese-Pct	1.643
MO	Molybdenum-Pct	.285	N	Nitrogen-Pct	.037
NI	Nickel-Pct	8.150	P	Phosphorus-Pct	.029
SI	Silicon-Pct	.289			

### Comments

# MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN  
740 IMPERIAL ROAD NORTH

Page : 2  
Heat/Lot : 86K8  
TIN : B42748

Material free from mercury contamination. No weld repairs.  
EN 10204 3.1 PED 97/23/EC Annex1, Para. 4.3 Q08763F Cond A  
This document certifies the material has been tested in  
accordance with applicable specifications described herein  
and has met those requirements.

QA by ERIC HESS 02/01/2006

## Miscellaneous Data

GURLEPH, OMN K123  
Control #: S0C60214  
Part #: 74270441  
.135 X 48 X 96

Date: 03/17/06

SOLD TO: INDIAN LAKE

TO 110880

S/O 90-374786 - 02

*[Signature]* 3/17/06

The Chemical Analysis and Mechanical Test  
data was received via EDI from the above  
mentioned vendor.

INTEGRIS METALS, LTD.